

Date: Thursday, 07/08/2008 4:23:24 PM
 User: Julie Lecocq

Process Sheet

SPLIT-1

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: ARM		
Job Number	: 41068			Part Number	: D3560043		
Estimate Number	: 12883			Drawing Number	: D3560 REV D		
P.O. Number	:			Project Number	: N/A		
This Issue	: 07/08/2008 S.O. No. :			Drawing Revision	: D		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : MACHINED PARTS			Due Date	: 26/08/2008 Qty: 10		
Previous Run	: 40300			Um:	Each		
Written By	:						
Checked & Approved By	: JLP 08.8.08						
Comment	: Est Rev:A New Issue 07.05.24 EC						
	Est Rev B ECN 987 07.10.09 EC						
	Est Rev:C ECN1048 07-12-18 DD verified by: EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0500X05000	6061-T6 Bar .500 x 5.00	
		Comment: Qty.: 1.3598 f(s)/Unit Total : 13.5975 f(s) 6061-T6 Bar 0.50" x 5.00" Batch: W/08854	JL 08/08/24
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks 15.500" long	JL 08/08/24
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 1- Mill as per Folio FA695 Rev: AA & Dwg D3560 Rev: D 2-C'sink 0.196" hole on manual mill as per dwg D3560 3-Deburr per dwg D3560	JLP 08/08/26 (12)
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	JLP 08/08/27 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 41068

Part Number: D3560043

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SD 08/09/09 (2)

6.0 D35921 Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

PLATE B41083 ✓

SP 08.09.09 (3X)

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

STEP:

1- clean material (buff bracket and bottom of arm with blue pad) SP

2- set up bracket and arm on jig SP

3- preheat bracket and arm with torch SP

4- clean before welding with brush SP

5- set up machine to 135 amps SP

6- weld across bottom and top ends SP

7- reheat with torch (65 deg C) SP

8- on one side weld from bottom to top half way SP

9- same for other side (half way) SP

10- from half way point weld the rest of the first side (ease off pedal near end) SP

11- same for remaining side (ease off pedal near end) SP

08.09.09 (3X)

8.0 QC5 INSPECT WORK TO CURRENT STEP



SD 08/09/09 (3)

Comment: INSPECT WORK TO CURRENT STEP

9.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-09-09 (3)

10.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M.F. 08/09/11 (3X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 07/08/2008 4:23:24 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: ARM
Job Number: 41068		Part Number: D3560043
Job Number:		
Seq. #:	Machine Or Operation:	Description :
11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		 F2 08/09/11 (3)
12.0	D2808	Bushing 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Spacer batch: 63713		
13.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Press bushing in D3560 arm per dwg D3562		 EP 08/09/11 (3)
14.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		 So 08/09/11 (3)
15.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 132		 X3 08/09/11 (3)
16.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		 08/09/11 (3)
Job Completion		 MF 08-09-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C-Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41068
Description: Arm	Part Number:	D3560-3
Inspection Dwg: D3560	Rev: B	Page 1 of 1

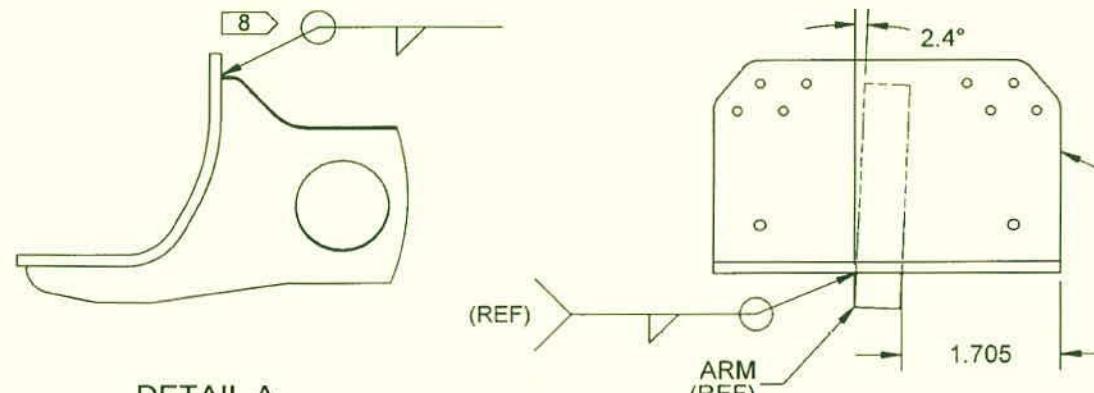
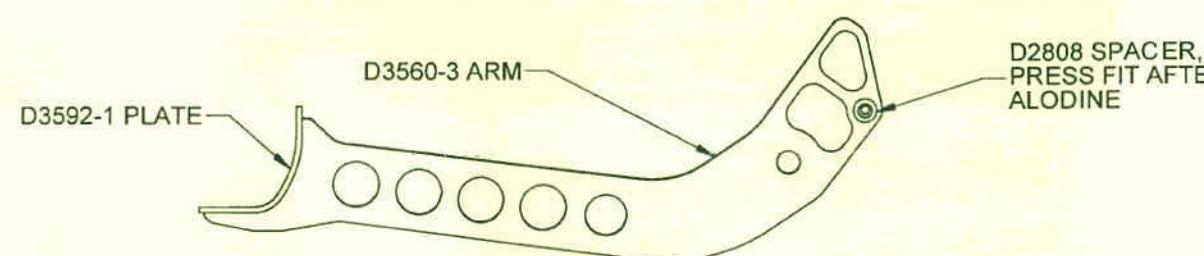
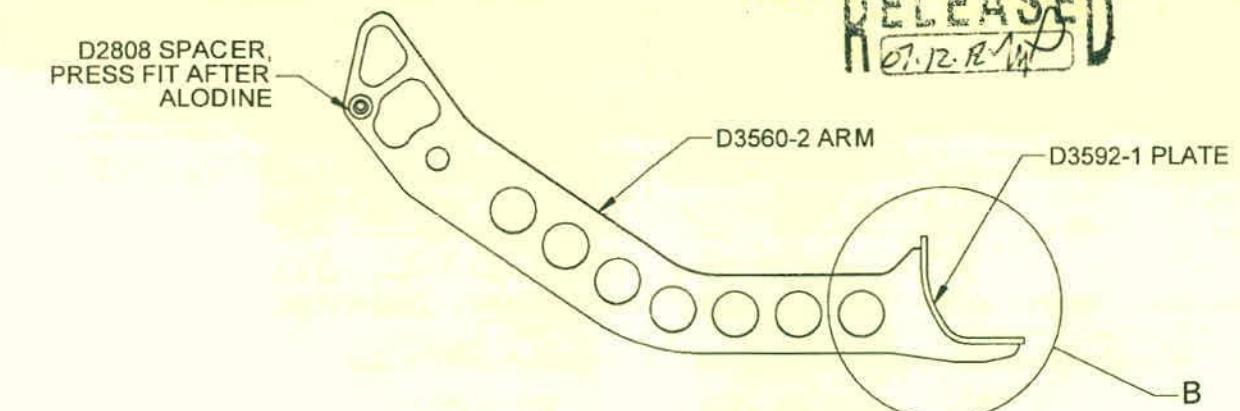
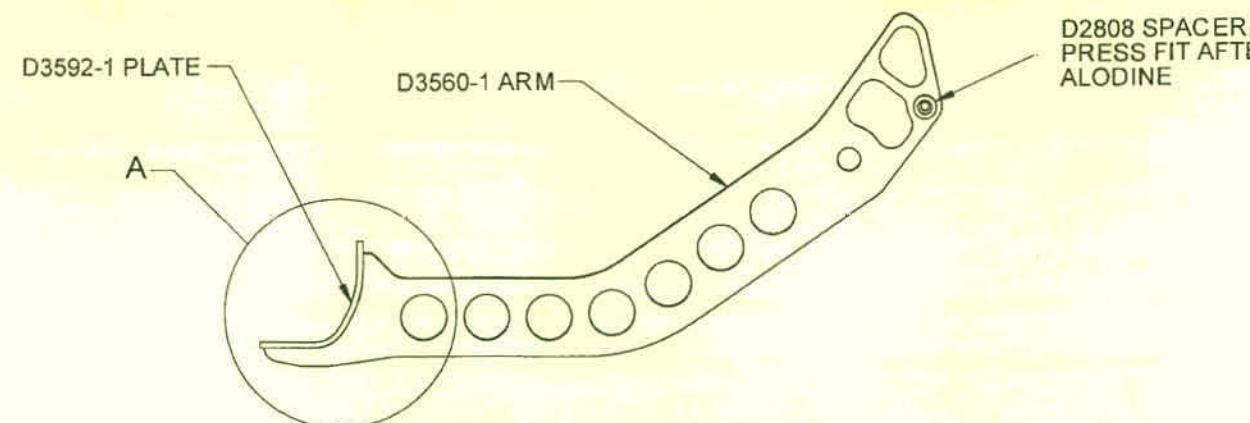
FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

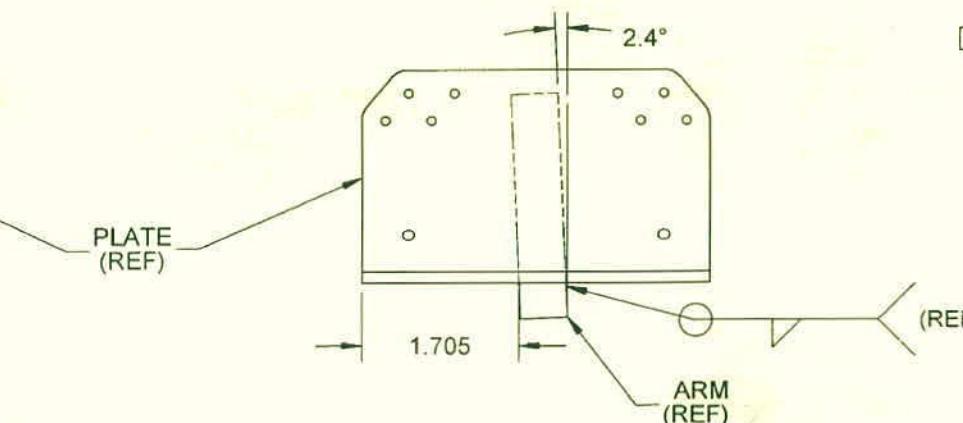
Measured by: <u>DJP</u>	Audited by: <u>SD</u>	Prototype Approval:	N/A
Date: <u>08/08/26</u>	Date: <u>08/07/26</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	

RELEASED
07.12.14



DETAIL A
SCALE 1 : 2



DETAIL B
SCALE 1 : 2

PARTS LIST

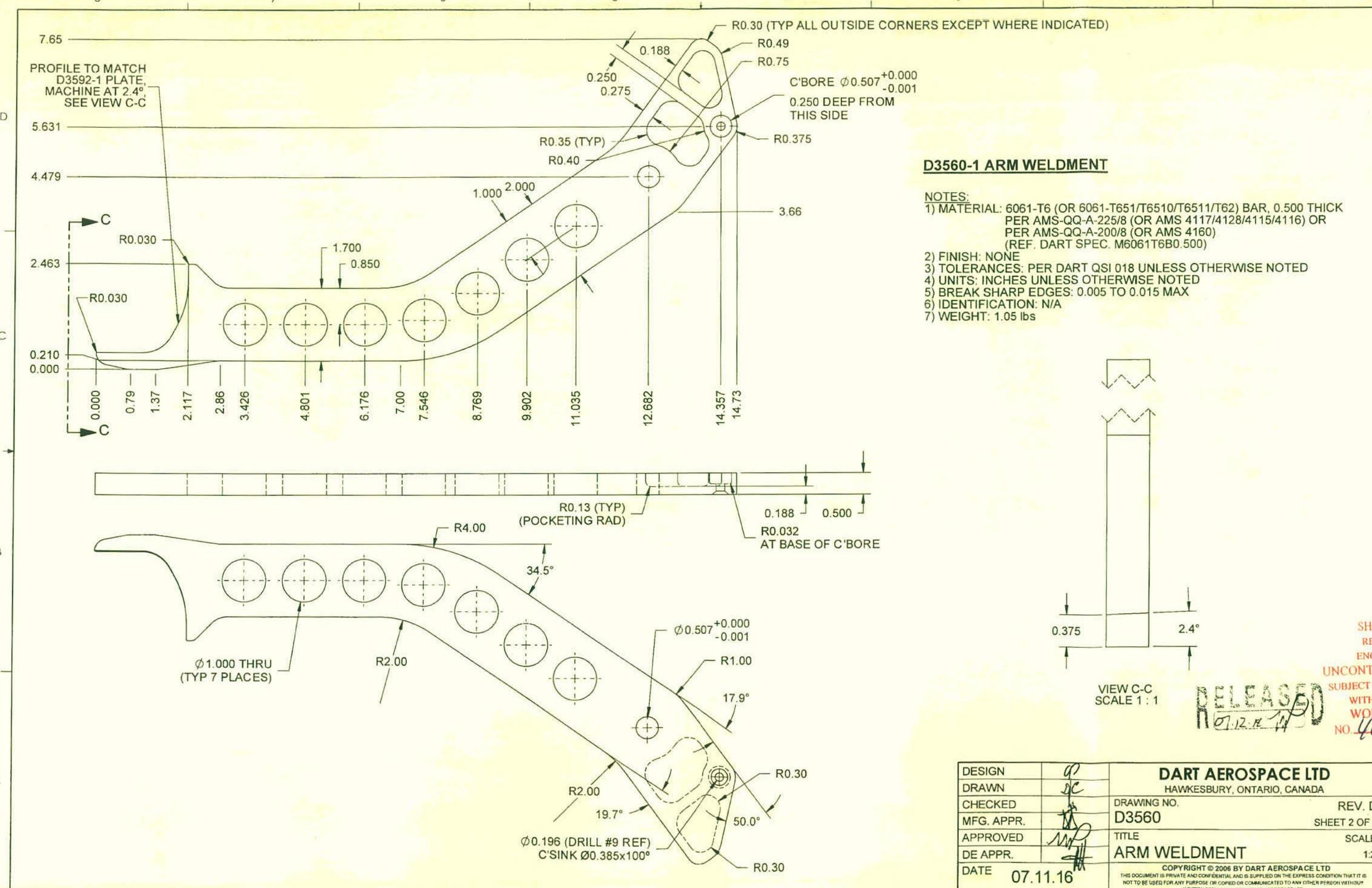
QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.23 lbs (TYP)
- 8) WELDING: PER DART QSI 004

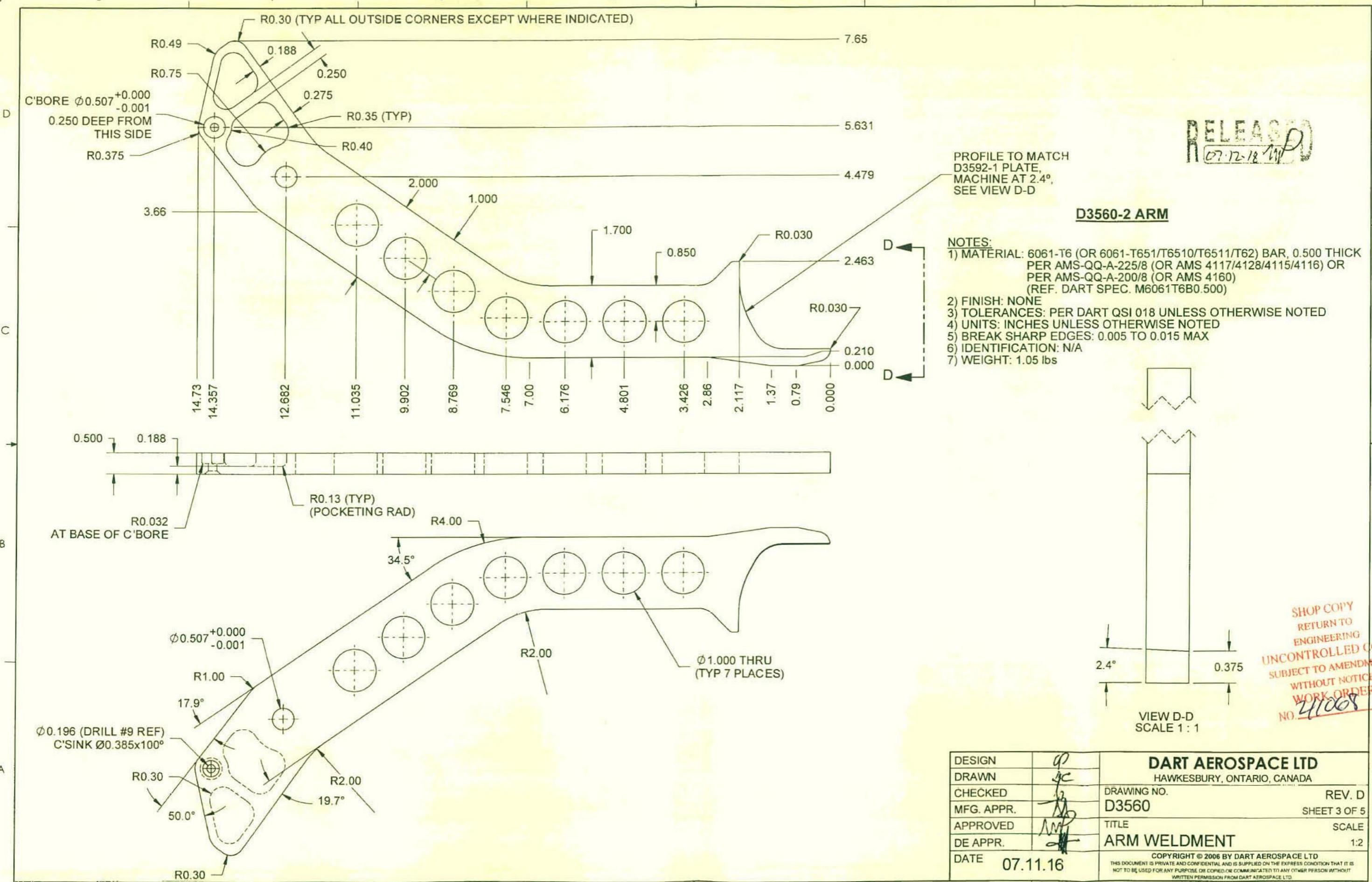
D	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16			
C	REMOVE POWDER COAT	CP	07.06.19			
B	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15			
A	NEW ISSUE	CP	06.09.25			
REV.	DESCRIPTION					
DESIGN	147					
DRAWN	JFC					
CHECKED	JG					
MFG. APPR.	JFC					
APPROVED	JFC					
DE APPR.	JFC					
DATE	07.11.16					
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA						
DRAWING NO. D3560						
REV. D						
SHEET 1 OF 5						
TITLE ARM WELDMENT						
SCALE 1:4						
COPYRIGHT © 2006 BY DART AEROSPACE LTD						
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.						





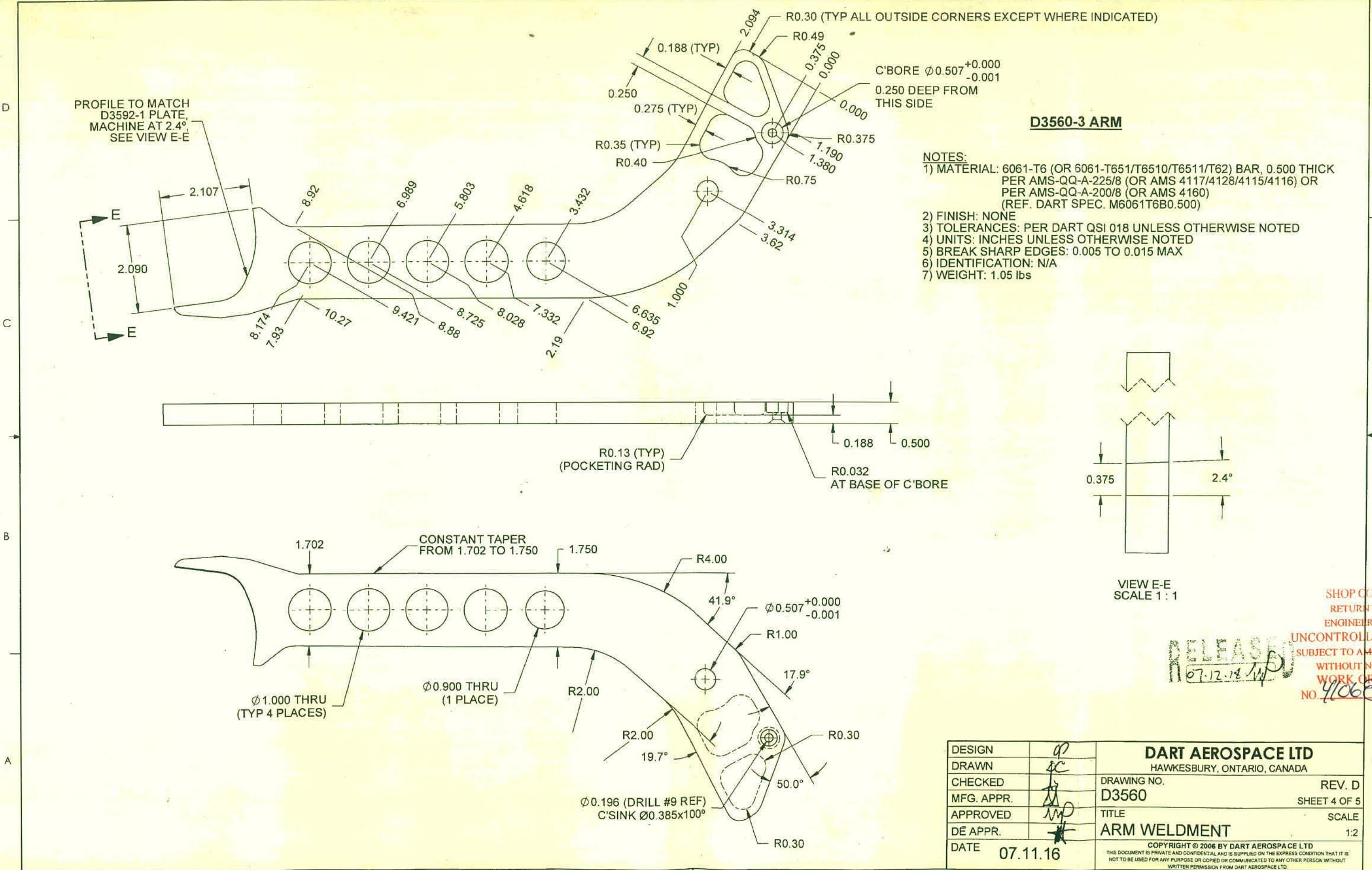
DESIGN	gp	DART AEROSPACE LTD
DRAWN	dc	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		D3560
APPROVED		REV. D
DE APPR.		SHEET 2 OF 5
DATE	07.11.16	SCALE
		1:2
ARM WELDMENT		
COPYRIGHT © 2006 BY DART AEROSPACE LTD		
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41068



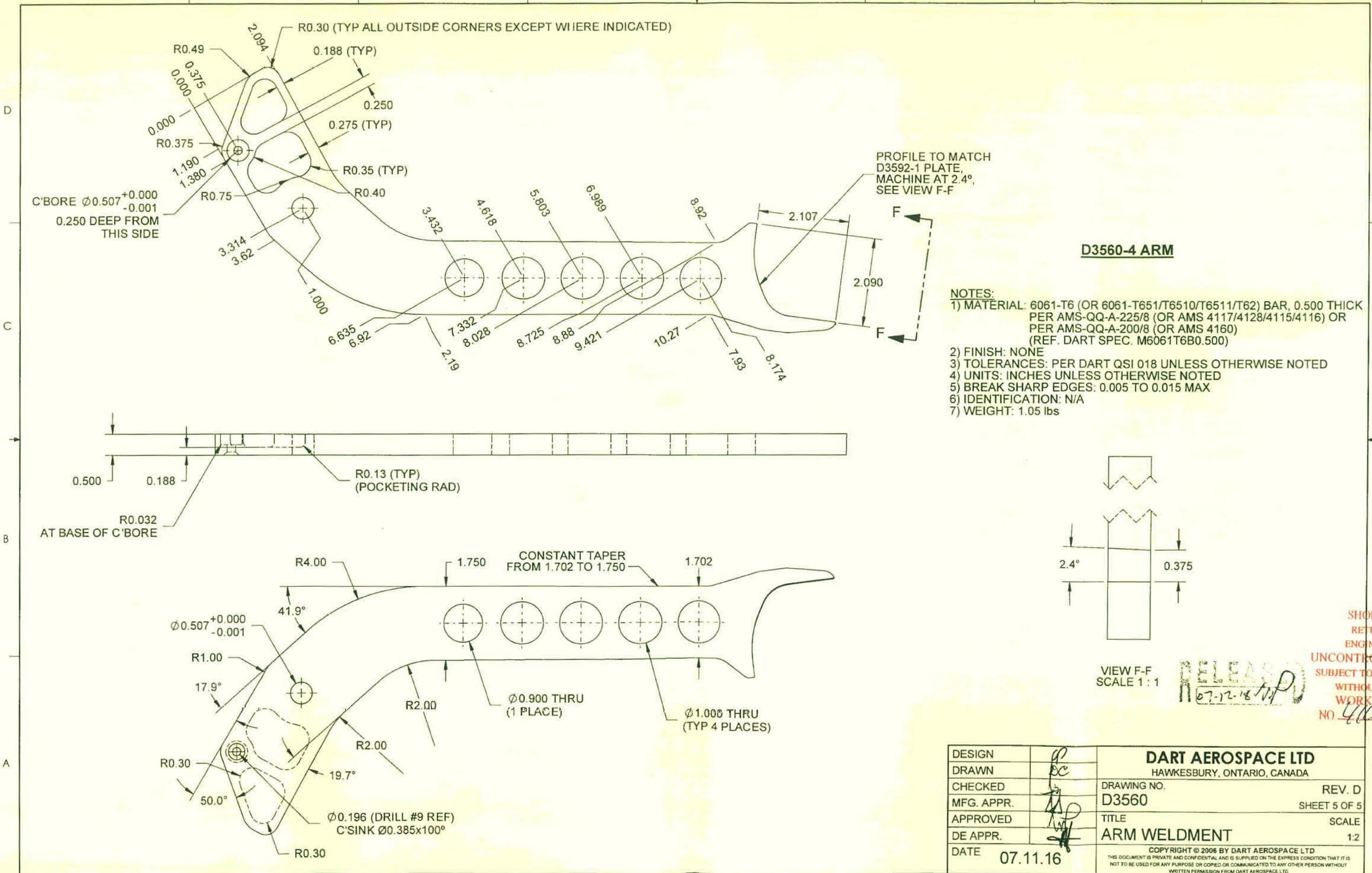


8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



DESIGN	<i>g</i>	DART AEROSPACE LTD
DRAWN	<i>DC</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>b</i>	DRAWING NO.
MFG. APPR.	<i>1</i>	D3560
APPROVED	<i>1</i>	REV. D
DE APPR.	<i>1</i>	SHEET 5 OF 5
DATE	07.11.16	TITLE
		ARM WELDMENT
		SCALE
		1:2

COPYRIGHT © 2006 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

